



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-591-311
Job Sheet 166386



Part No: D350-591-311

Job Qty: 1 ea

Part Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Production

Priority: Medium

Job Created: 10/1/17

Job Tracking No:

Due Date: 10/31/17

Created By: Linda Lacelle

Type: Stock

Description:

Customer: Airbus Helicopters - Marignane (CEURO24)

Aeroport International De Marseille Cedex Marignane Marseille, , 13725 France ph:+33 4 42 85 85 85 fx:+33 4 42 85 83 00.

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3272-1 JLM IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Part/Part Name	Part Note	Serial No	Quantity	Location
D350-591-311 Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible	DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3272-1 JLM IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC		0.000	
AN3-35A Bolt			0.000	
AN4-13A Bolt			0.000	
AN5-36A Bolt			0.000	
D2230-3 Mounting Lug	DWG REV G IPP D 00.05.18 Added inspection level 8, and removed P/O for powder coat EC IPP REV :E NEW FOLIO # 10-05-25 JLM VERIFIED BY:EC		0.000	
D2618 Bushing	DWG REV B1 IPP Rev:F Re-format 05-11-22 JLM		0.000	
D2856-400-720 Abrasion Strip 4" X 7.20"	DWG REV A IPP Rev:A 10.11.02 as per revA DD verf:EC		0.000	
D3065-041 Step Leg Assembly	DWG REV B IPP Rev: C 02.11.01 Incorporated D3066-1 IPP KJ/RF		0.000	
D3066-1 Spacer	DWG REV B IPP: C 02.11.01 Incorporated D3066-1 IPP KJ/RF IPP Rev:B Now M6061-T6 06-06-23 JLM		0.000	
D3067-1 End Plate	DWG REV A IPP: 03.01.21 Remove step 6 (Deburr) KJ IPP Rev:B Now on Water jet 06-06-16 JLM		0.000	
D3067-1 End Plate	DWG REV A IPP: 03.01.21 Remove step 6 (Deburr) KJ IPP Rev:B Now on Water jet 06-06-16 JLM		0.000	
D3219-1 Plate	DWG REV B IPP A 04.04.19 New issue KJ/JLM ESR B 06.05.25 Waterjet EC		0.000	
D3235-1 Mounting Lug	DWG REV A IPP A 04.04.19 New issue KJ			
D3272-1 Step	DWG REV B IPP Rev:A New Issue 07-06-0			
D3278-041 Support Assembly	DWG REV C IPP: A 04.04.19 New issue KJ/JLM IPP rivet per PAR185 EC Verified by: JLM			
MS20600-AD4W4 Rivet				
MS21042L3 Nut	DWG REV A			

Status: Stock

Part: D350-591-311 B166386

Created: 9/30/17 12:39 PM DART.MICHAUD-FEBRILLE.VICTORIA



Serial No: S000153

Printed By: Goldston, Justin 10/2/17 10:45 AM



S014470



Heli – Access – Step LH – High Gear, Long Step, Aerazur
Float Compatible

PART NO:

D350 – 591 – 311

Revision:

Operation:

Change No:

Powdercoat

Mfg Date: 11/28/17

Job No: 166386

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632 – 5200
Email: sales@dartaero.com
www.dartaerospace.com



S014470



Heli – Access – Step LH – High Gear, Long Step, Aerazur
Float Compatible

PART NO:

D350 – 591 – 311

Revision:

Operation:

Change No:

DC

Mfg Date: 11/28/17

Job No: 166386

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632 – 5200
Email: sales@dartaero.com
www.dartaerospace.com

MS21042L4	Nut	
MS21042L5	Nut	0.000
NAS1149D0363J	Washer	0.000
NAS1149D0463J	Washer	0.000
NAS1149D0563J	Washer	0.000

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea	10/30/17	0.00	0.00	Start up container	
100	DC	1 pcs	10/30/17	0.00	0.00	DC	
180	Large Fab	1 pcs	10/30/17	0.00	1.00	Large Fab 2	
220	Powdercoat	1 pcs	10/30/17	0.00	0.29	Powdercoat1	
230	HandFinish	1 pcs	10/31/17	0.00	0.19	HandFinish3	
240	QC	1 pcs	10/31/17	0.00	0.00	QC3	
250	Packaging	1 pcs	10/31/17	0.00	0.00	Packaging1	
260	QC	1 pcs	10/31/17	0.00	0.00	QC4	
270	Packaging	1 pcs	10/31/17	0.00	0.00	Packaging3	
280	QC21-FG	1 Ea	10/31/17	0.00	0.00	QC21	

Part Op 100 - Photocopy bluefile and type labels as per PPP D350-591-311 CHG001
 Descriptions: 180 - 1-Assemble Leg Assembly as per Dwg D3272
 220 - START TIME: 8:00 FINISH TIME: 11:30
 270 - Identify and pack for shipping as per PPPD350-591-311 Location : FG084

M12288 M138467.

ving walk M138423. 0.33.

DEC 08 2017

Job BOM

Part / Item	Component Name	Quantity	Operation	Special Comments
D350-591-311 B166386		1 Ea (1 ea)	90-Start up Operation	
D3067-1	End Plate	1 Ea (1 ea)	180-Large Fab	
MS20600-AD4W4	Rivet	16 Ea (16 ea)	180-Large Fab	
AN3-35A	Bolt	2 Ea (2 ea)	250-Packaging	
AN4-13A	Bolt	8 Ea (8 ea)	250-Packaging	
AN5-36A	Bolt	2 Ea (2 ea)	250-Packaging	
D2230-3	Mounting Lug	4 Ea (4 ea)	250-Packaging	
D2618	Bushing	2 Ea (2 ea)	250-Packaging	
D2856-400-720	Abrasion Strip 4" X 7.20"	2 Ea (2 ea)	250-Packaging	
D3235-1	Mounting Lug	2 Ea (2 ea)	250-Packaging	
D3278-041	Support Assembly	1 Ea (1 ea)	250-Packaging	
MS21042L3	Nut	2 Ea (2 ea)	250-Packaging	
MS21042L4	Nut	8 Ea (8 ea)	250-Packaging	
MS21042L5	Nut	2 Ea (2 ea)	250-Packaging	
NAS1149D0363J	Washer	4 Ea (4 ea)	250-Packaging	
NAS1149D0463J	Washer	16 Ea (16 ea)	250-Packaging	
NAS1149D0563J	Washer	4 Ea (4 ea)	250-Packaging	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D350-591-311 B166386	1	1	0	0
180-Large Fab	D3067-1	1	0	0	0
	MS20600-AD4W4	16	0	0	0
250-Packaging	AN3-35A	2	0	0	0
	AN4-13A	8	0	0	0
	AN5-36A	2	0	0	0
	D2230-3	4	0	0	0
	D2618	2	0	0	0
	D2856-400-720	2	0	0	0
	D3235-1	2	0	0	0
	D3278-041	1	0	0	0
	MS21042L3	2	0	0	0

✓ MS21042L4	5018879	8	0	0	0
✓ MS21042L5	5018878	2	0	0	0
✓ NAS1149D0363J	5018876	4	0	0	0
✓ NAS1149D0463J	5018875	16	0	0	0
✓ NAS1149D0563J	5018874	4	0	0	0

Part Specifications

Specifications could not be found.

Plex 10/1/17 12:56 PM Dart.Renwick.Jennifer

270

1x DSF 9410-011

5014470

Work Order Summary

Thursday, September 28, 2017 7:59:31 AM

Page 1 of 2

Criteria : Work Order ID: 166386 Item ID: D350-591-311 Product Family LARGE FAB
 Work Order Start Dates 9/19/2017 to 9/19/2017 11:59:59 PM Work Order Required Dates 9/29/2017 to 9/29/2017 11:59:59 PM
 All References
 Work Order Status Released

Work Order ID	166386	Required Qty	1.0000	Status Code	Released
Item ID	D350-591-311	Accepted Qty	0.0000	Scrap Qty	0.0000
Item Name	Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible				
Current Acct Value	\$703.537				
Start Date	9/19/2017	Required Date	9/29/2017	Completed Date	
Standard	** Actual **	** Acct. Value **	** Variance **	** Variance % **	
Direct Costs	Total	Each	Each	Each	Each
Material	\$28.624	\$0.000	\$151.003	\$151.003	100.00%
Labor	\$229.940	\$0.000	\$169.028	\$169.028	100.00%
Outplant	\$0.000	\$0.000	\$0.002	\$0.002	100.00%
Variable Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Fixed Burden	\$486.962	\$0.000	\$383.504	\$383.504	100.00%
Material Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
** Total **	\$745.526	\$0.000	\$703.537	\$703.537	

Item ID/Item Name	Required Qty	Issue Code	Issue Date	Issued Qty	Cost Amount
D3065-041 Step Leg Assembly	1.0000		9/21/2017	1.0000	\$72.082
D3066-1 Spacer	2.0000		9/21/2017	2.0000	\$8.709
D3067-1 End Plate	1.0000		9/21/2017	1.0000	\$2.531
D3219-1 Plate	2.0000		9/20/2017	2.0000	\$7.022
D3272-1 Step	1.0000		9/21/2017	1.0000	\$52.824
Total Matl Amts:					\$143.167

Work Center HandFinish

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
LECO02												
		9/20/2017										
140			0.00	0.00	0.85	0.42	2.00	\$0.000	\$9.221	\$23.017	\$0.000	\$32.239
		9/22/2017										
210			0.00	0.00	1.20	0.40	3.00	\$0.000	\$8.726	\$21.781	\$0.000	\$30.508

Total:	0.00	0.00	2.05	0.82	5.00	\$0.000	\$17.948	\$44.799	\$0.000	\$62.746
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Work Center Large Fab

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
LU01												
		9/20/2017										
110			0.00	0.00	3.60	3.60	1.00	\$0.000	\$77.484	\$157.274	\$0.000	\$234.758
		9/21/2017										
180			0.00	0.00	3.11	3.11	1.00	\$0.000	\$66.936	\$135.864	\$0.000	\$202.800
180			0.00	0.00	0.83	0.83	1.00	\$0.000	\$17.882	\$36.295	\$0.000	\$54.177
180			0.00	0.00	0.74	0.74	1.00	\$0.000	\$15.803	\$32.075	\$0.000	\$47.878
Total:			0.00	0.00	8.28	8.28	4.00	\$0.000	\$178.104	\$361.509	\$0.000	\$539.613

Work Order ID 166386

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Tuesday, September 19, 2017 12:58:44 PM

Item ID: D350-591-311 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible
 Start Date: 9/19/2017 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 9/29/2017 Req'd Qty: 1.00 *1* Customer:
 Reference:

SEP 19 2017
 Approvals: Process Plan: cu Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3272	Rev B

100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and type labels as per PPP D350-591-311 CHG001								

110	Weld per dwg A/R Aluminum rod Batch: _____	0.00							
110	Large Fab								
Large Fab	Memo	0.32							
Large Fab	1-Bevel end for welding FWD ONLY								
	2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272								
	A/RAluminum Rod <u>M137078</u>								
	3-Grind End Plate flush								

x1 S.L 2017-9-20

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Item ID: D350-591-311 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible
Start Date: 9/19/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/29/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				1	SEP 20 2017		DAS 24 9-89
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				1	SEP 20 2017		DAS 24 9-89
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.20				①	SEP 20 2017		DAS 24 9-89 JSL

Work Order ID 166386

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Item ID: D350-591-311

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 9/19/2017 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 9/29/2017 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

QC7-Inspect Chemical Conversion Coat

0.00

150

QC

Memo

0.01

Quality Control

1 SEP 21 2017 DAS 24 9-89

180

Weld per dwg A/R Aluminum rod Batch: _____

0.00

180

Large Fab

Large Fab

Memo

0.28

Large Fab

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272
A/RAluminum Rod M137078

6-Grind End Plate flush

7-Install last rivet as per Dwg.

x1 S.L 2017-9-21

Work Order ID 166386

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Page 4

Item ID: D350-591-311**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Stop *NS2*****Item Name:** Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible**Start Date:** 9/19/2017 **Start Qty:** 1.00***1*****Cust Item ID:****Required Date:** 9/29/2017 **Req'd Qty:** 1.00***1*****Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start *NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC10- Inspect visual per QSI004- ground welds	0.00							
190									
QC	Memo	0.00							
Quality Control									
200	QC5- Inspect part completeness to step on W/O	0.00							
200									
QC	Memo	0.02							
Quality Control									
210	Chemical Conversion Coat per QSI005 4.1	0.00							
210									
HandFinish	Memo	0.07							
Hand Finishing									

SEP 22 2017

DAS
24
9-89

SEP 22 2017

DAS
24
9-89① 2017-09-22
FL

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[illegible]

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Page 6

Item ID: D350-591-311**Accept*****N900040100*****Setup Start*****NS1*****Revision ID:****Stop*****NS2*****Item Name:** Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible**Start Date:** 9/19/2017 **Start Qty:** 1.00***1*****Cust Item ID:****Required Date:** 9/29/2017 **Req'd Qty:** 1.00***1*****Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start*****NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop*****NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							
250									
Packaging	Memo	0.01							
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
260									
QC	Memo	0.03							
Quality Control									
270	Identify as per dwg & Stock Location: _____	0.00							
270									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD350-591-311 Location : FG084								

Work Order ID 166386

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Item ID: D350-591-311**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Stop *NS2*****Item Name:** Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible**Start Date:** 9/19/2017 **Start Qty:** 1.00 ***1*****Cust Item ID:****Required Date:** 9/29/2017 **Req'd Qty:** 1.00 ***1*****Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start *NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop *NR2*****Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

280

QC21- Final Inspection - Work Order Release

0.00

280

QC

Memo

0.10

Quality Control

Picklist Print

Page 1

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Work Order ID: 166386

166386

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 9/19/2017

Required Date: 9/29/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A04.03.22New issue KJ/RF
IPP Rev:B 07-06-09 Added D3272-1 JLM
IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC
IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3-35A

Purchased

No

250

Each

62.0000

2

2

AN3-35A

Bolt

Location

Loc Qty

Loc Code

FG

10

122800

10

ST348

52

M138170

52

AN4-13A

Purchased

No

250

Each

114.0000

8

8

AN4-13A

Bolt

Location

Loc Qty

Loc Code

FG

20

122808

20

GA

9

m135470

9

ST344

85

m138326

85

AN5-36A

Purchased

No

250

Each

44.0000

2

2

AN5-36A

Bolt

Location

Loc Qty

Loc Code

ST336

44

m137963

44

Picklist Print

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Work Order ID: 166386

166386

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 9/19/2017

Required Date: 9/29/2017

Start Qty: 1.00

Required Qty: 1.00

D2230-3 Manufactured No 250 Each 204.0000 4 4

D2230-3

Mounting Lug

Location

Loc Qty

Loc Code

FG

4

109344

4

ST521

200

163291

40

164011

160

D2618 Manufactured No 250 Each 21.0000 2 2

D2618

Bushing

Location

Loc Qty

Loc Code

ST008A

21

163460

1

164495

20

D2856-400-720 Manufactured No 250 Each 180.0000 2 2

D2856-400-720

Abrasion Strip 4" X 7.20"

Location

Loc Qty

Loc Code

FG

41

158146

1

161232

40

ST418

139

165231

139

Picklist Print

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Work Order ID: 166386

166386

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 9/19/2017

Required Date: 9/29/2017

Start Qty: 1.00

Required Qty: 1.00

D3065-041

Manufactured No

180

Each

27.0000

1

1

D3065-041 ✓

Step Leg Assembly

**

x1 S.L 2017-9-21

Location

Loc Qty

Loc Code

WA002

27

162415

2

164384

1

165204

14

165610

10

x1

D3066-1

Manufactured No

180

Each

93.0000

2

2

D3066-1 ✓

Spacer

**

x2 S.L 2017-9-21

Location

Loc Qty

Loc Code

WA003

93

159117

4

162500

10

165744

79

x2

D3067-1

Manufactured No

110

Each

94.0000

1

1

D3067-1 ✓

End Plate

**

Location

Loc Qty

Loc Code

WA003

94

163742

6

165725

56

166077

32

x1 SL 2017-9-20

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Shop Packet Print

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Picklist Print

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Work Order ID: 166386

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Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 9/19/2017

Required Date: 9/29/2017

Start Qty: 1.00

Required Qty: 1.00

D3067-1

Manufactured No

180

Each

94.0000

1

1

D3067-1 ✓

End Plate

**

x1 SL 2017-9-21

Location

Loc Qty

Loc Code

WA003

94

163742

6

165725

56

166077

32

D3219-1

Manufactured No

110

Each

60.0000

2

2

D3219-1 ✓

Plate

**

Location

Loc Qty

Loc Code

WA003

60

162848

2

166070

16

166284

42

D3235-1

Manufactured No

250

Each

51.0000

2

2

D3235-1

Mounting Lug

**

x2 SL 2017-9-20

Location

Loc Qty

Loc Code

ST522

51

162757

51

D3272-1

Manufactured No

110

Each

15.0000

1

1

D3272-1 ✓

Step

**

Location

Loc Qty

Loc Code

WA003

15

164968

1

165582

10

166023

2

166372

2

~~166386~~ x1 S.L 2017-9-20
B166387 ↗

Picklist Print

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Work Order ID: 166386

166386

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 9/19/2017

Required Date: 9/29/2017

Start Qty: 1.00

Required Qty: 1.00

D3278-041

Manufactured No

250

Each

47.0000

1

1

D3278-041

Support Assembly

Location

Loc Qty

Loc Code

ST522

47

160701

2

162850

1

164347

20

165569

24

MS20600-AD4W4

Purchased

No

180

Each

1,197.000

16

16

MS20600-AD4W4

Rivet

Location

Loc Qty

Loc Code

ST308

29

M138209

29

WA003

1168

M135442

204

M136986

108

M137412

63

M137820

21

M138209

81

5014466 M138441

691

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Picklist Print

Tuesday, September 19, 2017 12:58:44 PM

Work Order ID: 166386

166386

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 9/19/2017

Required Date: 9/29/2017

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

250

Each

1,421.000

2

2

MS21042L3******

Nut

LocationLoc QtyLoc Code

FP001

44

m135945

44

GA

302

m134360

102

M136665

200

OVER007

500

m138408

500

ST303

575

m137495

12

m138230

500

m138326

63

MS21042L4

Purchased

No

250

Each

1,766.000

8

8

MS21042L4******

Nut

LocationLoc QtyLoc Code

FP001

10

m133363

10

OVER007

500

m138230

500

ST303

1256

m138170

500

m138326

756

Picklist Print

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Tuesday, September 19, 2017 12:58:44 PM

Work Order ID: 166386

166386

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 9/19/2017

Required Date: 9/29/2017

Start Qty: 1.00

Required Qty: 1.00

MS21042L5 Purchased No 250 Each 353.0000 2 2

MS21042L5******

Nut

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
GA	8	
m127813	8	
ST303	345	
m137963	45	
m138209	200	
m138336	100	

NAS1149D0363J Purchased No 250 Each 1,195.000 4 4

NAS1149D0363.J******

Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
GA	408	
m137963	408	
ST263	787	
m138336	787	

NAS1149D0463J Purchased No 250 Each 1,746.000 16 16

NAS1149D0463.J******

Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
GA	445	
M135056	40	
M137699	405	
Return2017	16	
M136665	16	
ST263	1285	
M137988	600	
M138230	685	

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Work Order ID: 166386***166386*****Parent Item:** D350-591-311***D350-591-311*****Parent Item Name:** Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible**Start Date:** 9/19/2017**Required Date:** 9/29/2017**Start Qty:** 1.00**Required Qty:** 1.00

NAS1149D0563J

Purchased

No

250

Each

1,286.000

4

4

NAS1149D0563.J******

Washer

LocationLoc QtyLoc Code

GA

36

m135774

36

ST263

1250

m138040

550

m138209

700

Tuesday, September 19, 2017 12:58:44 PM

Shop Packet Print

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DESIGN <i>GP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE N/A
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07.06.04-*ff*

△
B

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 166386

CU

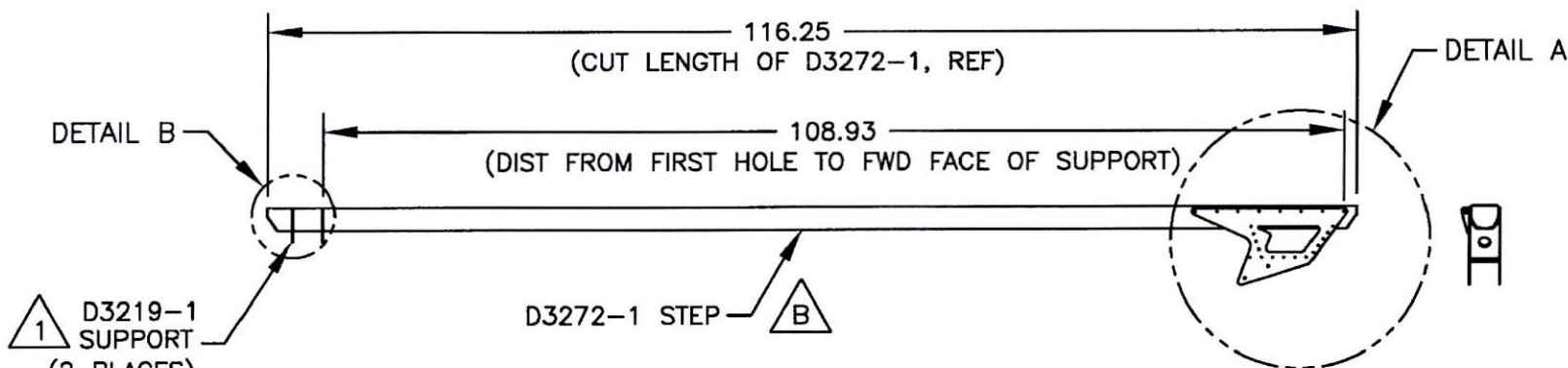
SEP 19 2017

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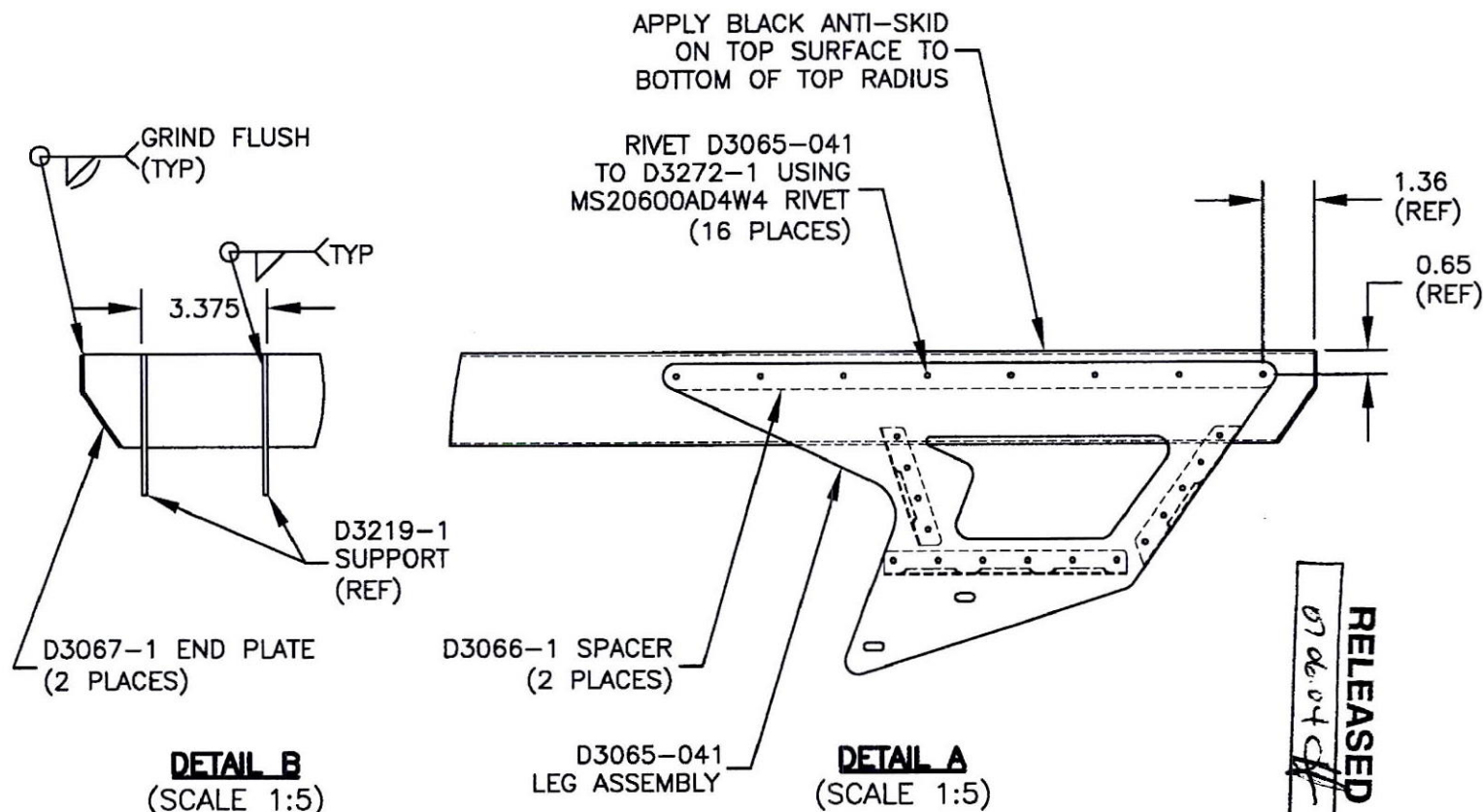
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DART

DESIGN	90	DRAWN BY	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	CE	APPROVED	JB	DRAWING NO. D3272
DATE	07.05.18	TITLE	STEP ASSEMBLY, HI LONG	REV. B
				SHEET 2 OF 3
				SCALE 1:20



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)

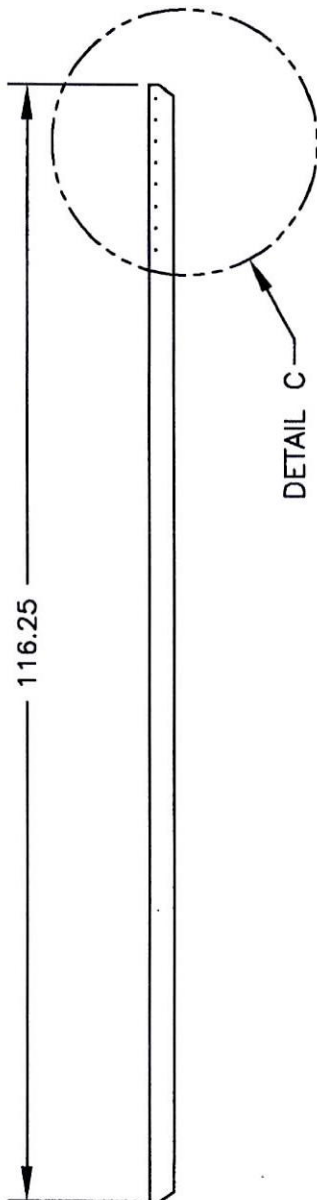




DESIGN <i>GP</i>	DRAWN BY <i>JB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18	TITLE STEP ASSEMBLY, HI LONG		SCALE 1:20

RELEASED

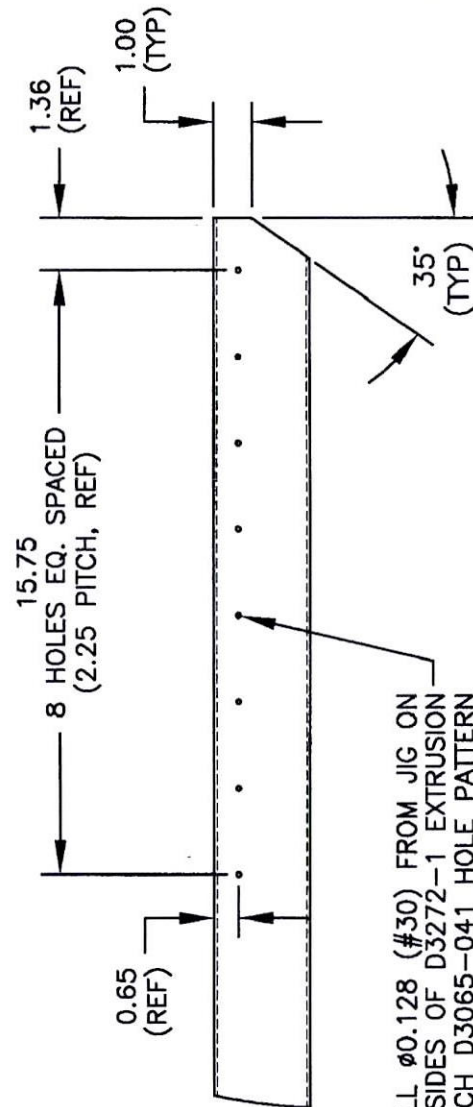
07.06.04 *[Signature]*



DETAIL C

B D3272-1 STEP

(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL $\phi 0.128$ (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

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Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
	X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
		X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
			X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
				X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
					X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.